

Work Order ID 119882-2

May-28-14 2:52:26 PM

119882

Page 1

Item ID: D5062-041

Revision ID:

Item Name: Bracket Assembly

Start Date: 5/28/14

Start Qty: 20.00

Required Date: 6/05/14

Req'd Qty: 20.00

Reference:

Accept

D5062-101

B119882

20

20

N9000040100

Cust Item ID:

Customer:

Setup Start

NS1

Stop

NS2

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5062	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D5062-1F as per Dwg								
	Dwg Rev: A								
	Prog Rev: A								
	2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

mm
DAS
37
9-89

14-06-02

mm
DAS
37
9-89

14-06-02

Work Order ID 119882

May-28-14 2:52:26 PM

119882

Page 2

Item ID: D5062-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket Assembly

Stop ***NS2***

Start Date: 5/28/14 Start Qty: 20.00

20

Required Date: 6/05/14 Req'd Qty: 20.00

20

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Bend as per dwg and transfer drill
holes to size as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

DAS
30
9-89

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DAS
27
9-89

Work Order ID 119882

May-28-14 2:52:26 PM

119882

Page 3

Item ID: D5062-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket Assembly
 Start Date: 5/28/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 5/05/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

Hand Finish

Memo

0.00

Hand Finishing

17 7/6 14/6-4

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

17x 14/06/05

DAS
36
9-89

170

0.00

170

Small Fab

Memo

0.00

Small Fab

INSTALL RIVET AS PER DWG

17x 14/06/05

DAS
36
9-89

Work Order ID 119882

119882

Page 4

May-28-14 2:52:26 PM

Item ID: D5062-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket Assembly
 Start Date: 5/28/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 6/05/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 SM M/G/S				17			
190 *190* SprayPaint Spray Painting	Memo PRIME AS PER DWG AND PER QSI 005 A/R PRIMER, IAW MIL-P-23377J TYPE 1 CLASS N BATCH: <u>127 401</u>	0.00 0.00				17			CR 14-06-08
200 *200* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00 DAS 27 9-89 M/G/S				17			

Work Order ID 119882

119882

Page 5

May-28-14 2:52:26 PM

Item ID: D5062-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket Assembly
 Start Date: 5/28/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 6/05/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>SK</u>	0.00							
210									
Packaging	Memo	0.00							
Packaging									
22H	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

17X SP14-6-9
 14/6/9
 14-6-9

Picklist Print

May-28-14 2:52:25 PM

Page 1

Work Order ID: 119882

119882

Parent Item: D5062-041

D5062-041

Parent Item Name: Bracket Assembly

Start Date: 5/28/14

Required Date: 6/05/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 14.02.11 NEW ISSUE DD VERF:JLM IPP
REV:B 14.05.28 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No				sf	381.5600		5			

M6061T6S 080

6061-T6 .080 Sheet

**

mm 17/06/01

Location

Loc Qty

Loc Code

MAT021

381.56

m126309

130.52

m126350

13.34

m128903

237.7

5.3

MS20470AD4-5

Purchased

No

Each

3,255.000

80

MS20470AD4-5

RIVET, UNIVERSAL HEAD

**

14/06/05 DAS 36 9.89

Location

Loc Qty

Loc Code

ST336

3255

m126926

339

m128401

1653

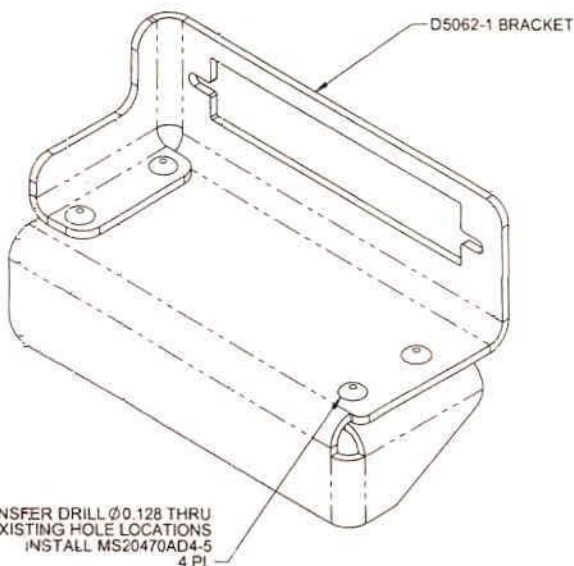
m128813

1263

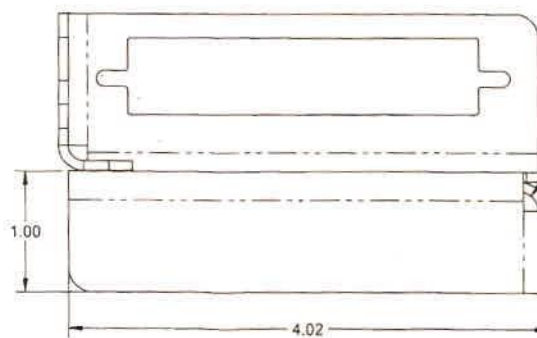
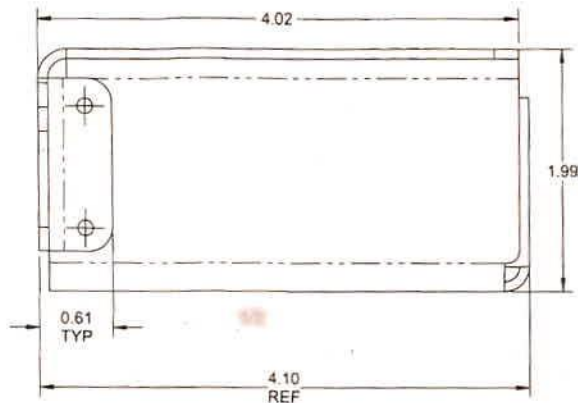
68

ITEM	QTY-041	P/N	DESCRIPTION
	X	D5062-041	BRACKET ASSY
1	1	D5062-1	BRACKET
2	4	MS20470AD4-5	RIVET, PANHEAD

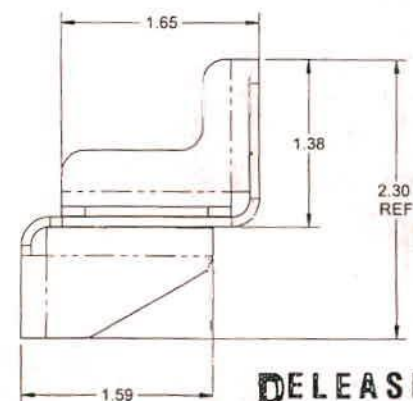
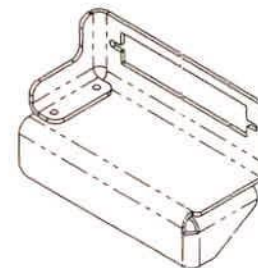
W10119882



D5062-041 BRACKET ASSY



D5062-1 BRACKET
MAKE FROM D5062-1F

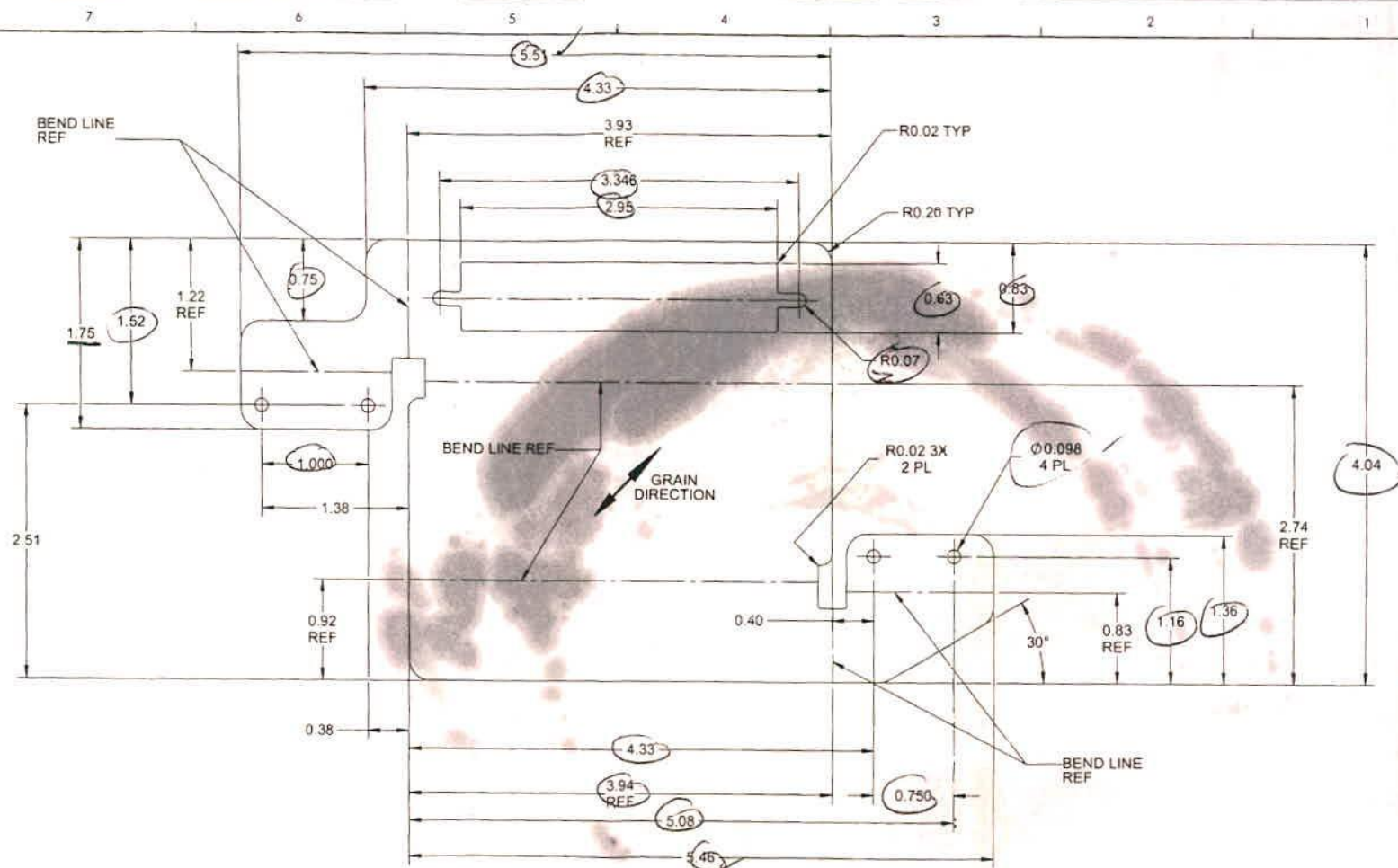


RELEASED
2014-05-28

NOTES:

- 1) MATERIAL: MAKE FROM D5062-1F
- 2) FINISH: D5062-1: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1.
D5062-041: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5062-041" PER QSI 044.6.1
- 7) WEIGHT: 0.13lbs

A NEW ISSUE		DB 14.02.10	
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5062	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	BRACKET	N/T
DATE 14.02.10		COPYRIGHT © 2014 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION THROUGH DART AEROSPACE LTD.</small>	



D5062-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC. M6061T6S.080)
- 2) FINISH: D5062-1F- NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D5062-1F-A.DXF"

RELEASE
2014-05-28

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5062	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	14.02.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE (SPECIFIED OR UNSPECIFIED) TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	